



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C45-3-11
Job Sheet 171689



Part No: C45-3-11

Job Qty: 20 ea

Part Name: Actuator



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: C45-3-11 rev.8 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		2/8/18	0.00	0.00	Start Up Machining-4		
120	CNC Lathe	20 pcs		2/9/18	0.50	4.00	MORI NLX		
130	QC	20 pcs		2/9/18	0.00	0.00	QC2 Machining-5		
140	QC	20 pcs		2/9/18	0.00	0.00	QC8 Machining-5		
150	Packaging	20 pcs		2/9/18	0.00	0.00	Packaging3-2		
160	QC21-FG	20 Ea		2/9/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per folio FB820 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 150 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-R2.000	M174R2.000	3.5000 ft (.175 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-R2.000	4	0	0

Part Specifications

Specifications could not be found.



Container No: S042953



Part: C45-3-11

Job No: 171689

Serial No/Batch: S042953

Revision: C45-3-11

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Max 2/7/18 11:55 AM Dart.lajeunesse.marie

Date: 02/16/18

1.3

128 809
36 1/2
23 1/4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order:	171689
Description: Actuator		Part Number:	
Inspection Dwg: C45-3-11	Rev: 8	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.19 x 45°	±.01 x .5°	.190 x 45°	✓			vern LPO9
Ø.390	±.005	.393				
.77	±.01	.773				
Ø.714	±.005	.711				
Ø.800	±.005	.800				
2.025	±.005	2.025				
.215	±.005	.215				
.381	±.005	.381				
.468	±.005	.468				
.188	±.005	.188				
.140	±.005	.140				
1.020	±.005	1.022				
.530	±.005	.528				
.265	±.005	.263				
.250	±.005	.250				
.06	±.01	.06				
Ø.624	+0.00 / -.004	.627				
Ø.684	+0.00 / -.004	.682				
Ø.800	±.005	.800				
Ø.680	+0.00 / -.004	.678				
.317	±.005	.317				
.02 x 45°	±.01 x .5°	.02 x 45°				
.03 x 45°	±.01 x .5°	.03 x 45°				
.950	±.005	.950				
.850	±.005	.851				
1.285	±.005	1.285				
.620	±.005	.618				Height Gage
.700	±.005	.698				
.063	±.005	.061				

Measured by: 18-02-15	Checked by: G.	QC Inspector:
Date:	Date: 18-02-19	Date:

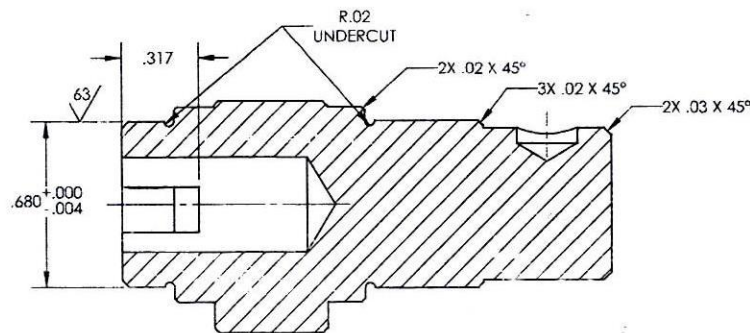
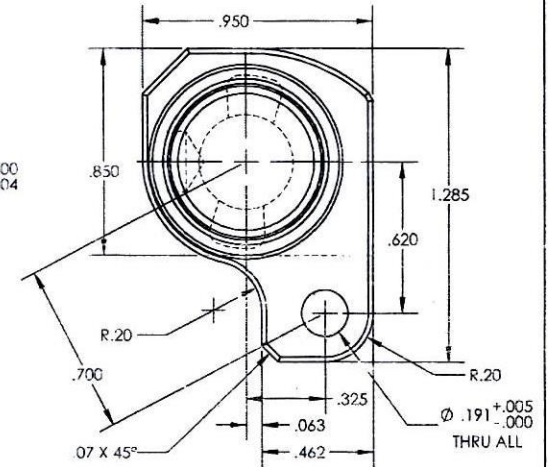
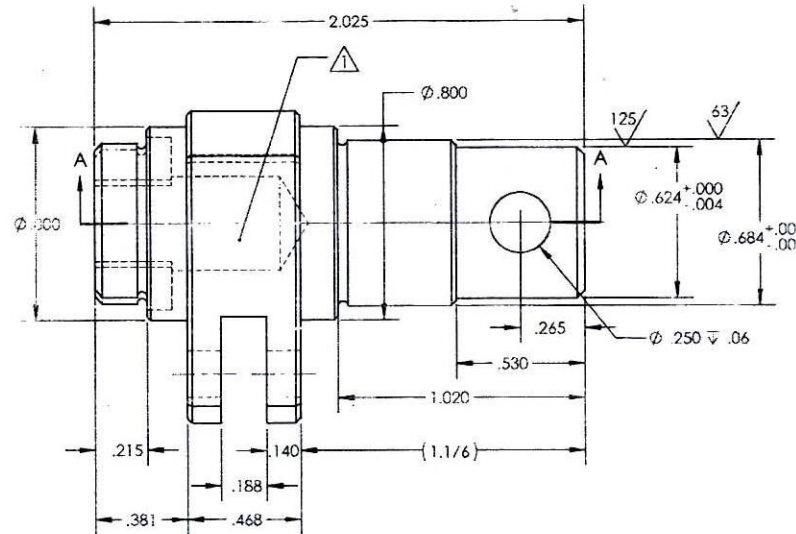
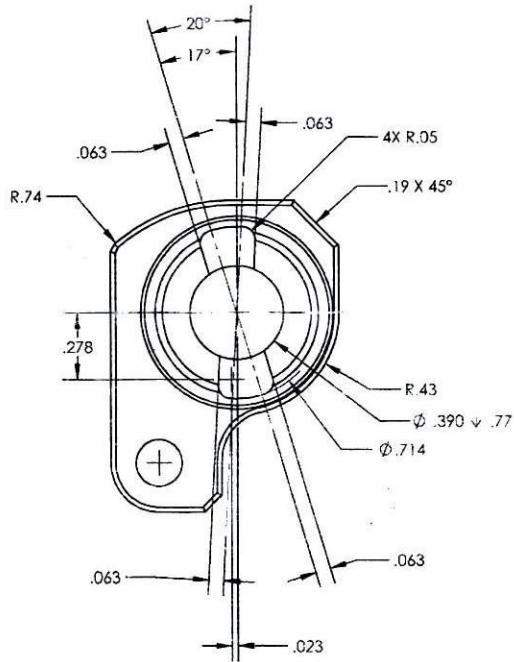
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

424
2150
2.9

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REVISIONS				DATE	INITIALS	APPROVED
REV	ECR	DESCRIPTION				
6		AS DRAWN BY CANAM		9/12/2012	RJC	
7		CHANGED HOLE FROM Ø.188 TO Ø.191		10/30/2012	JAG	
8	14/1/15	CHD TITLE BLOCK WAS RED BARN S DART. ADDED MACHINE ENGRAVE NOTE CHD TOLERANCE ON NON-CRITICAL DIMENSIONS CHD BOM INFO WAS 1.3.1.1/2 X 1.1/4 B Ø2.4.2.1/8		8/13/2014	DPD	RW



SECTION A-A

NOTE:
MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE ACTUATOR	
DWG NO C45-3-11	REV 8
MATERIAL 17-4 SS	DRAWN BY CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D. Mott</i>
XXX ±.005 XX ±.01 X ±.1	FRACTIONS ± 1/8 ANGLES ± 5° FINISH
1. BREAK ALL SHARP EDGES .015 ± 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 2:1	DATE 1/28/1998
SHEET 1 OF 1	

ASTY QTY	ASTY QTY	B/C	Part #	Unit QTY	Description	Material	P/O INFORMATION OR SPECIFICATION
			C45-3-11	1	ACTUATOR	17-4 SS	027 2-1/8

196
392

716